

Date: Thursday, 2/14/2008 11:01:33 AM  
 User: Kim Johnston

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: PANEL
Job Number	: 37442		
Estimate Number	: 10906		
P.O. Number	:	Part Number	: D33303
This Issue	: 2/14/2008 S.O. No. :	Drawing Number	: D3330 REV D
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: / / Type : SMALL /MED FAB	Drawing Revision	: D
Previous Run	: 35487	Material	:
Written By	:	Due Date	: 3/15/2008 Qty: 6 Um: Each
Checked & Approved By	:		
Comment	Est. A 05.01.13 New issue KJ/JLM Est Rev:B Now on Waterjet 06-09-25 JLM est C 07.05.14 rev C dwg ec Est D 07.12.12 Rev D dwg EC verified by:DD		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	M1010S125	1010-1025 sheet .125
-----	-----------	----------------------



Comment: Qty.: 0.7130 sf(s)/Unit Total: 4.2777 sf(s)  
 1010-1025 sheet .125  
 Batch: 106140 1B 8-2-22

2.0	WATER JET	FLOW WATER JET
-----	-----------	----------------



Comment: FLOW WATER JET  
 1-Cut as per Dwg D3330  
 Dwg Rev: C  
 Prog Rev: C

1B 8-2-22

⑥

2-Deburr if necessary 1B 8-2-22

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
-----	-----	--------------



Comment: SECOND CHECK

2002-25 ⑥

5.0	PACKAGING 1	PACKAGING RESOURCE #1
-----	-------------	-----------------------



Comment: PACKAGING RESOURCE #1  
 Identify and Stock  
 Location: \_\_\_\_\_

57488

AS 08/03/11 ⑦⑥

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: D Date: 08/03/12  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 2/14/2008 11:01:33 AM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: PANEL

Job Number: 37442

Part Number: D33303

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC21

FINAL INSPECTION/W/O RELEASE



⑥

Comment: FINAL INSPECTION/W/O RELEASE

D00103/12

Job Completion



in 2008/3/12

⑥

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			


**NOTE:** Date & initial all entries

DART AEROSPACE LTD		Work Order:	37442
Description: Plate		Part Number:	D3330-3
Inspection Dwg: D3330	Rev: <i>C D</i>		Page 1 of 1

## FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article    ☐ Prototype

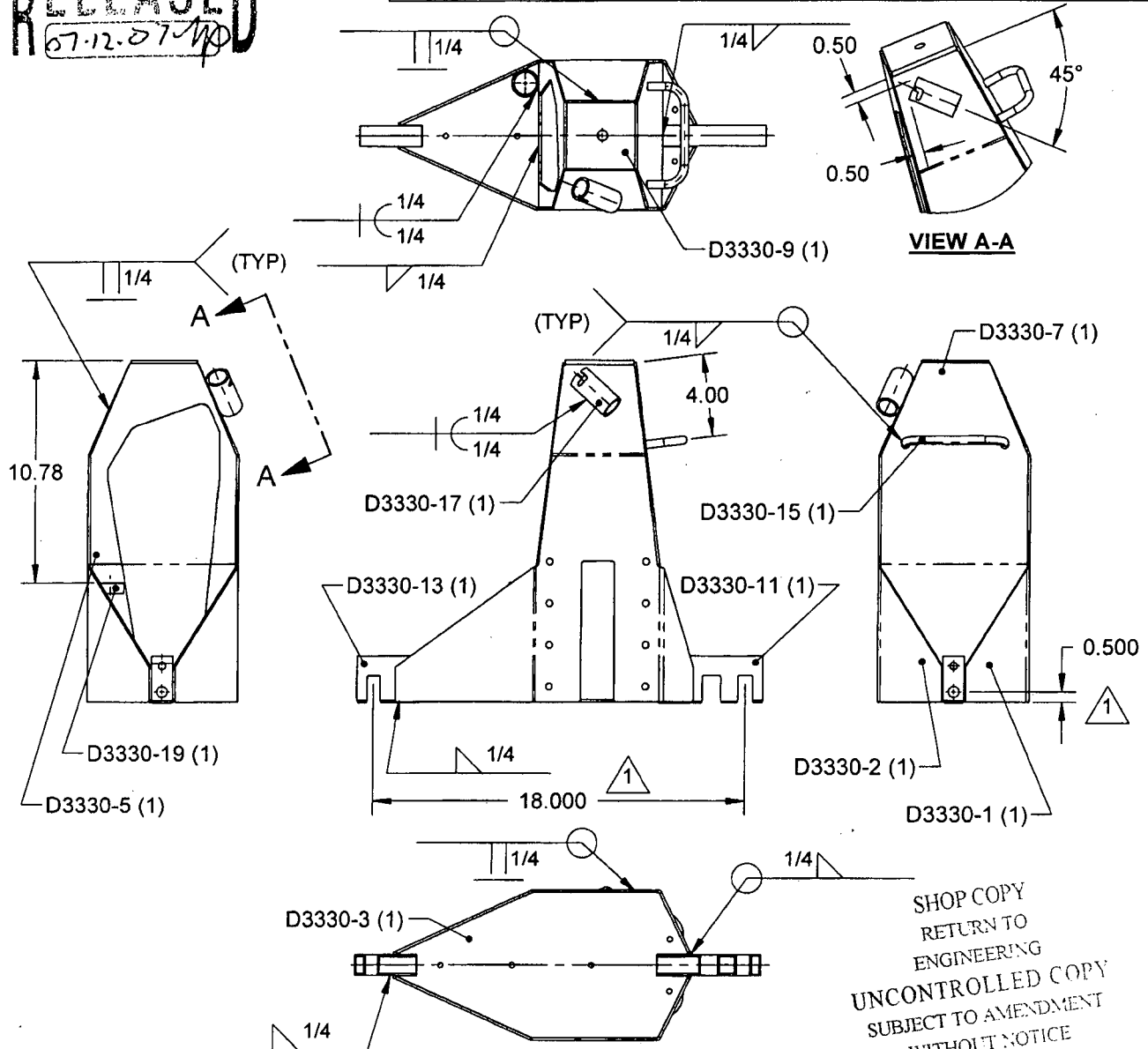
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Measured by:	HB	Audited by:		Prototype Approval:	N/A
Date:	8-2-25	Date:	8-2-25	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	07.05.16	New Issue	KJ/JLM <i>[Signature]</i>	<i>[Signature]</i>

**DART****RELEASED**  
07-12-07

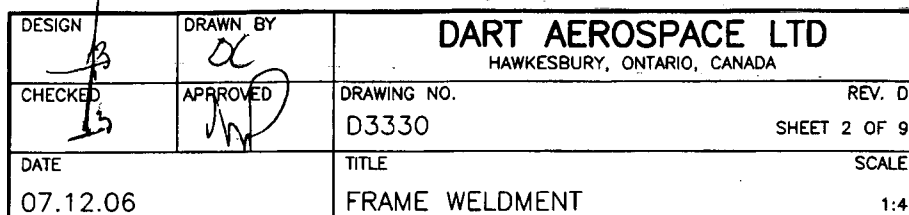
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CHECKED <i>JB</i>	APPROVED <i>WFP</i>	DRAWING NO. <b>D3330</b>	REV. D SHEET 1 OF 9
DATE <b>07.12.06</b>		TITLE <b>FRAME WELDMENT</b>	SCALE 1:8
REV	DATE	DESCRIPTION	
A	04.12.16	NEW ISSUE	
B	05.02.26	RE-DESIGN	
C	07.03.20	ADD 0.100 DIM: RAISED BEND OF -1/-2 BY 0.125	
D	07.12.06	CHANGE DIMS ON D3330-9	

**D3330-041 FRAME WELDMENT****NOTES:**

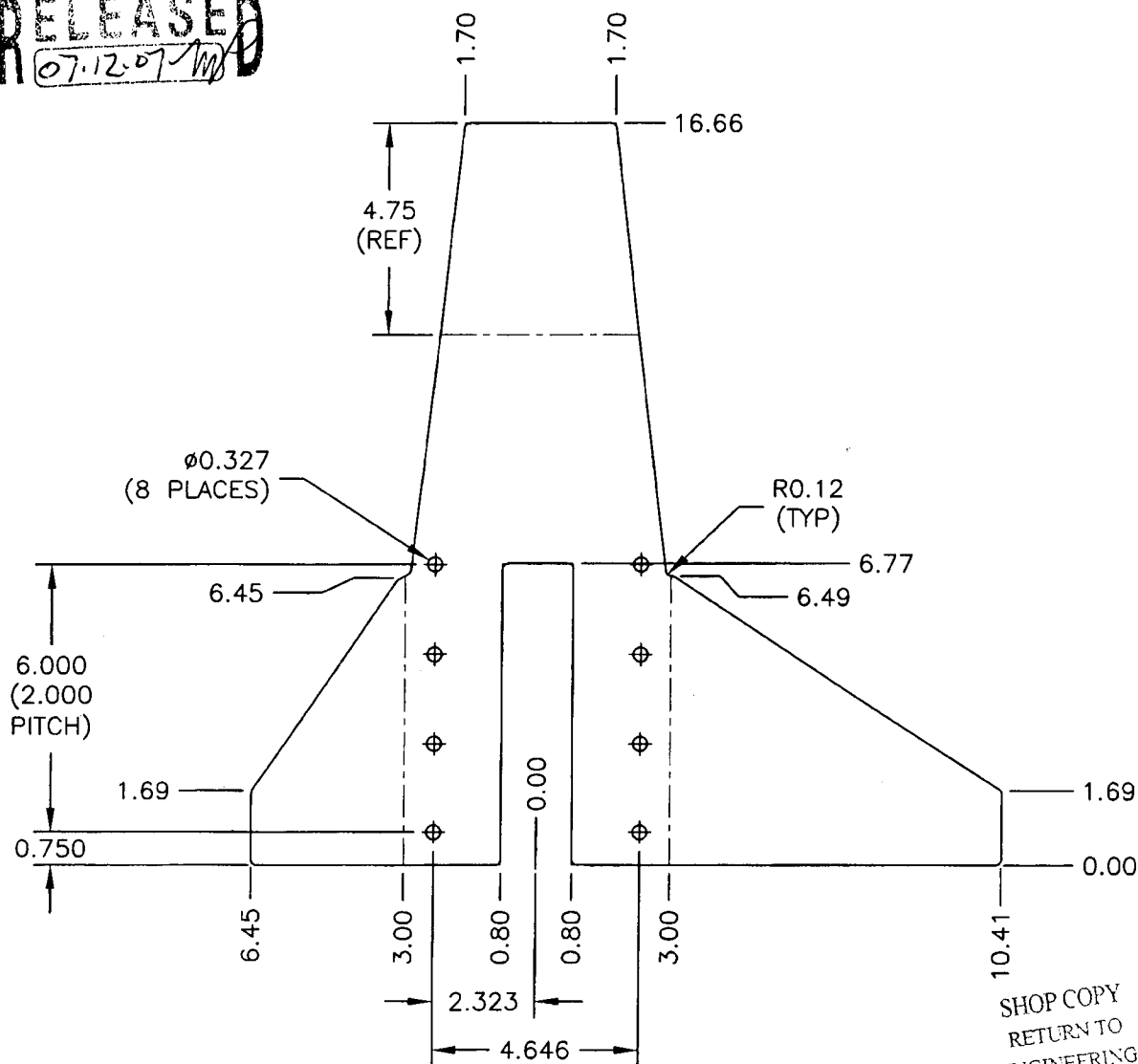
- 1) POSITION PARTS AS PER JIG D3330-041T1
- 2) WELD PER QSI 004
- 3) FINISH: POWDER COAT PAINT FIRE RED (4.3.5.10) PER DART QSI 005 4.3
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.010 TO 0.020

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D3330-1 PANEL

NOTES:

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21,  
38W/44W/50W/60W/70W SERIES STEEL 11 GAUGE (0.125 THICK)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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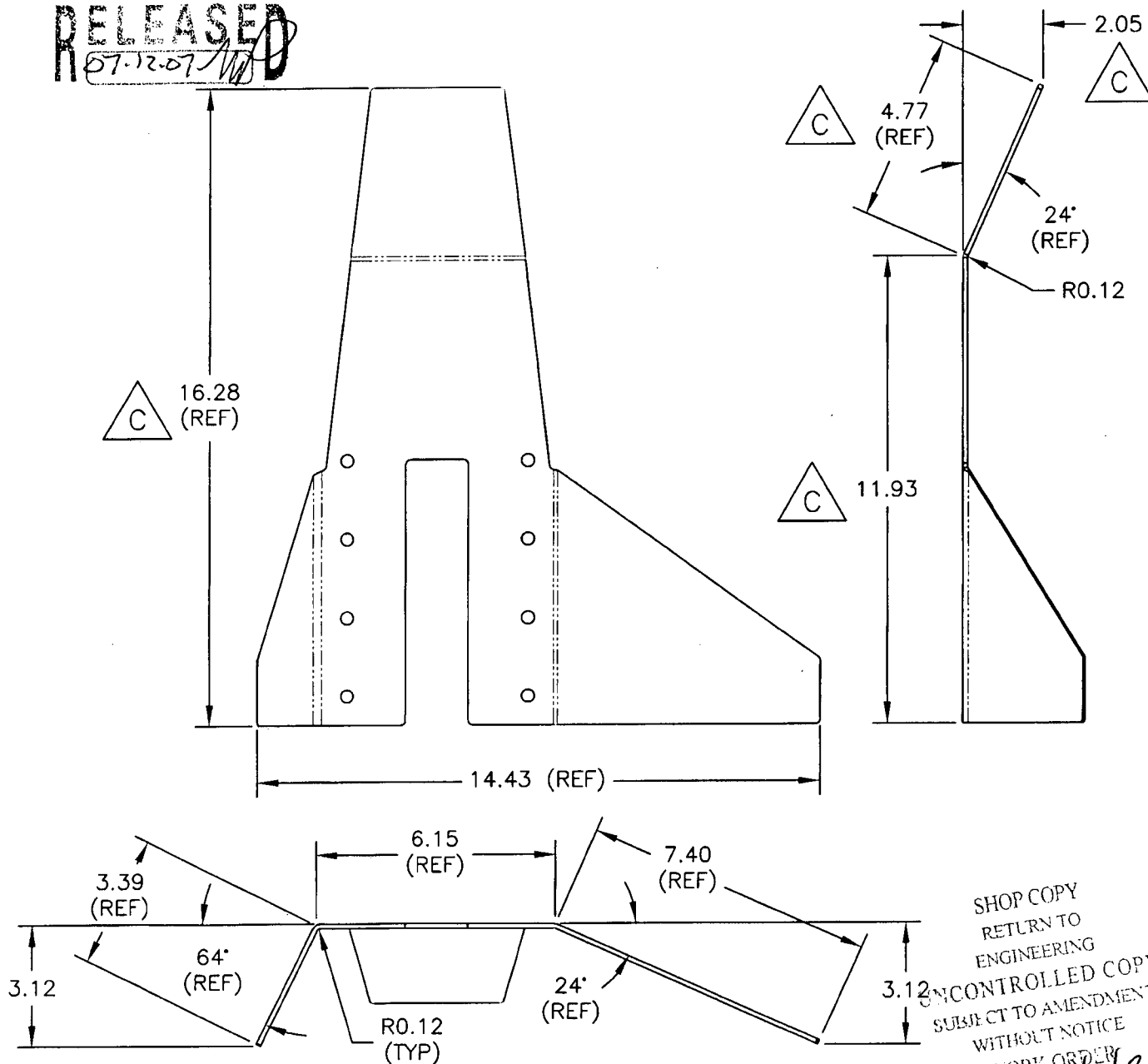
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DATE 07.12.06		TITLE FRAME WELDMENT	SCALE 1:4

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07-12-07



**D3330-1 BEND DETAIL (SHOWN)**  
BEND D3330-2 (OPPOSITE)

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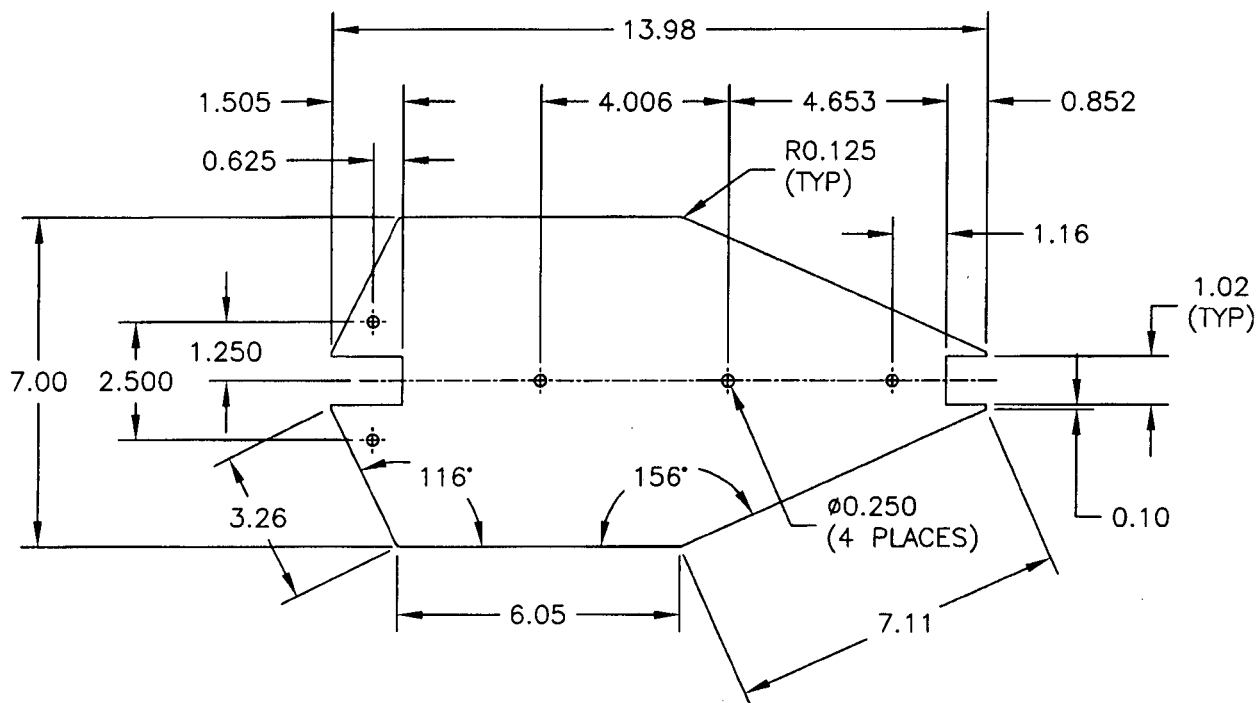
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### D3330-3 PLATE

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#### NOTES:

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W SERIES STEEL 11 GAUGE (0.125 THICK)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

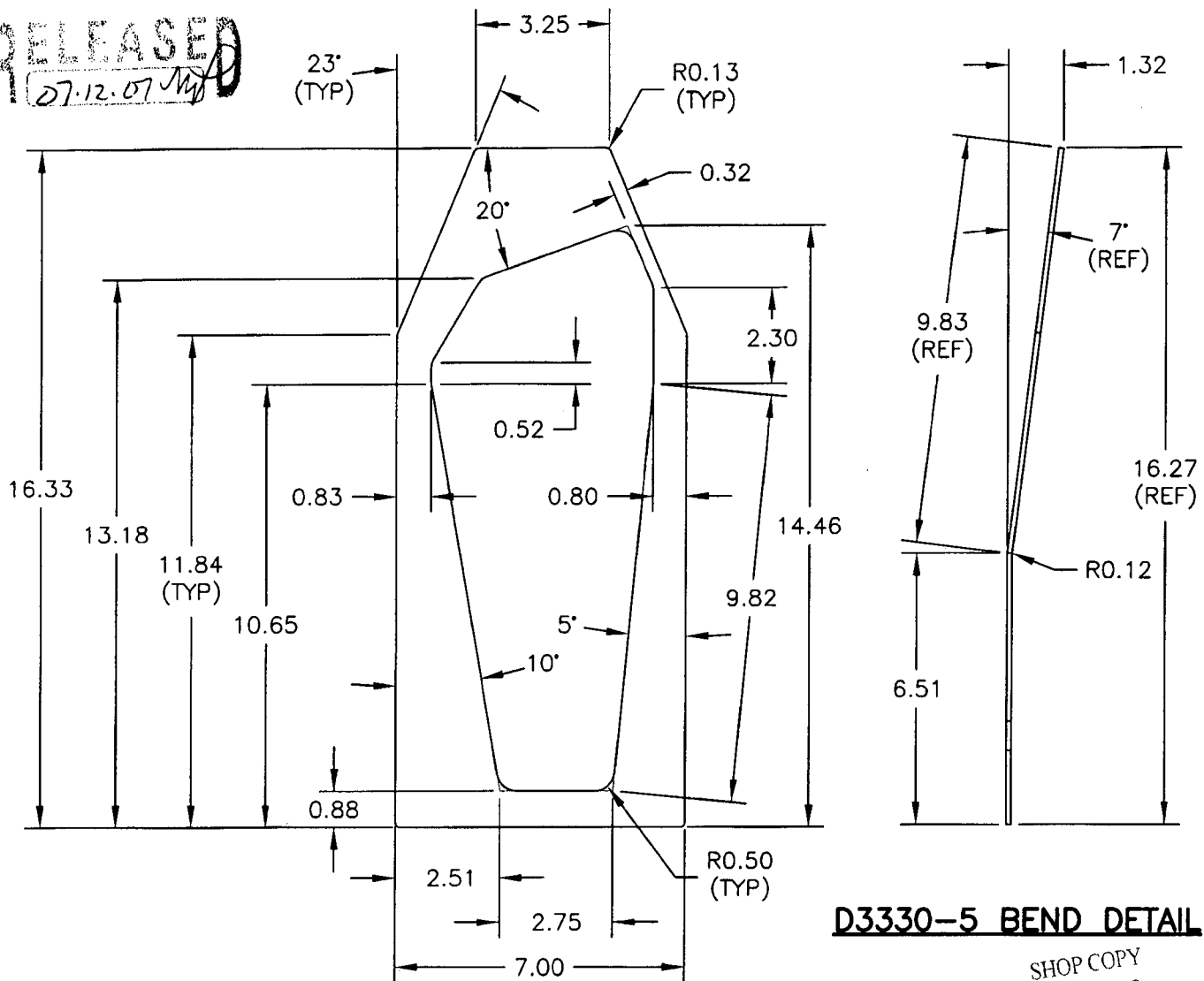
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DATE 07.12.06		TITLE FRAME WELDMENT	SCALE 1:4

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07.12.07 *MD*



### FLAT PATTERN

### D3330-5 BEND DETAIL

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#### NOTES:

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W SERIES STEEL 11 GAUGE (0.125 THICK)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

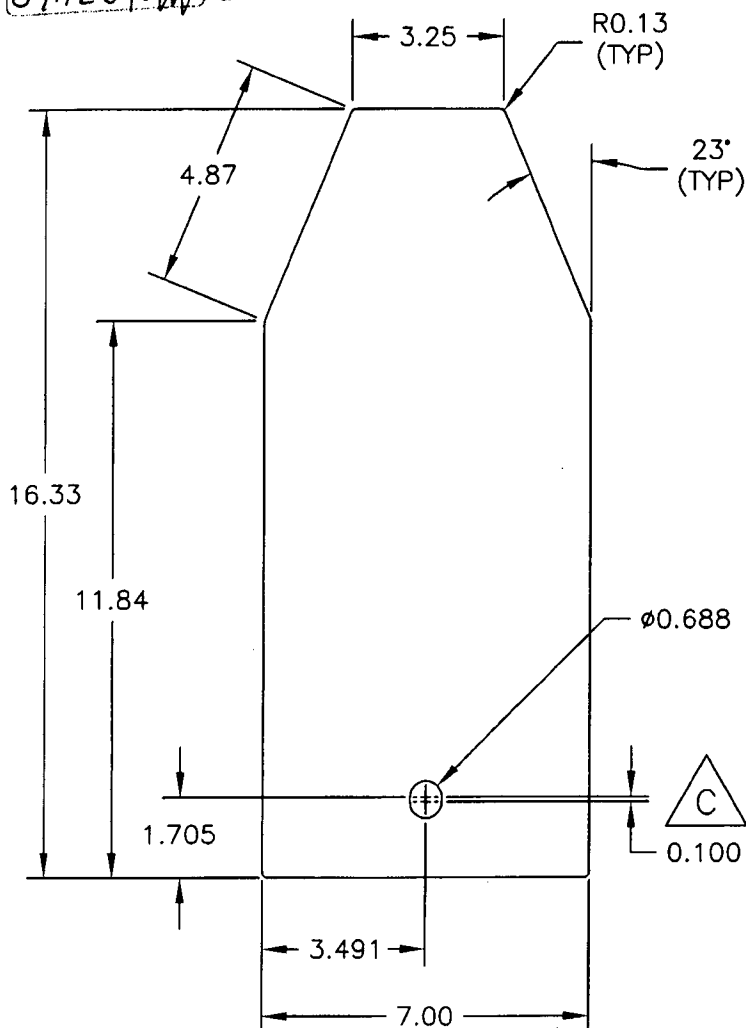
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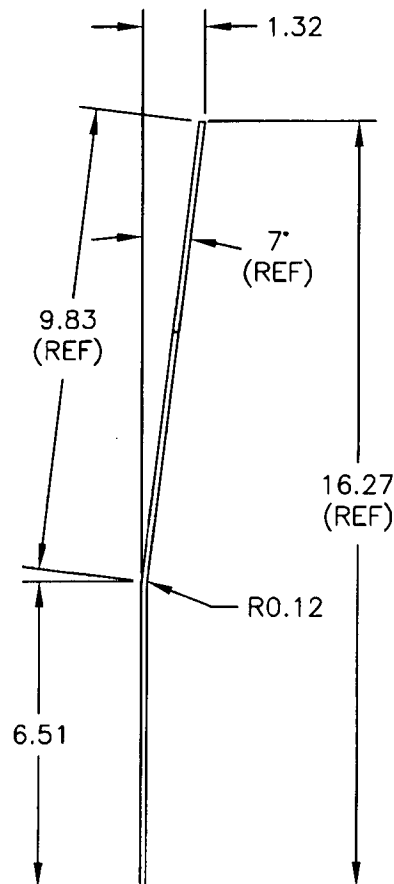


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DATE 07.12.06		TITLE FRAME ASSEMBLY	SCALE 1:4

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R 07.12.07 MB



**FLAT PATTERN**



**D3330-7 BEND DETAIL**

**NOTES:**

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W SERIES STEEL 11 GAUGE (0.125 THICK)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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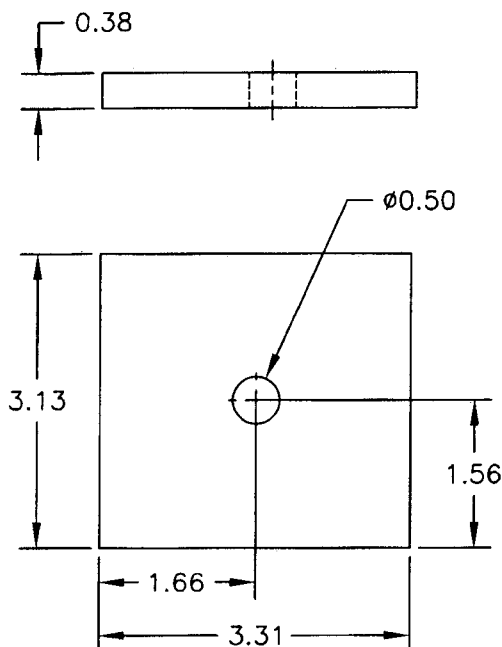
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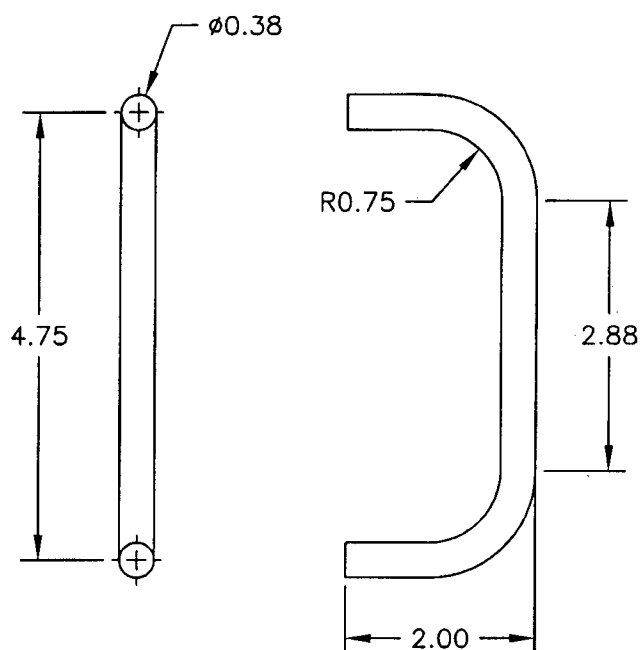


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DATE 07.12.06		TITLE FRAME WELDMENT	SCALE 1:2

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1 D3330-9 TOP PLATE



2 D3330-15 HANDLE

NOTES:

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008, 0.375 STEEL (REF. DART SPEC. M1010-B0.375x3.500)
- 2) MATERIAL: AISI 1018-1025 ROUND BAR PER MIL-S-7097 (REF. DART SPEC. M1018-R0.375)
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

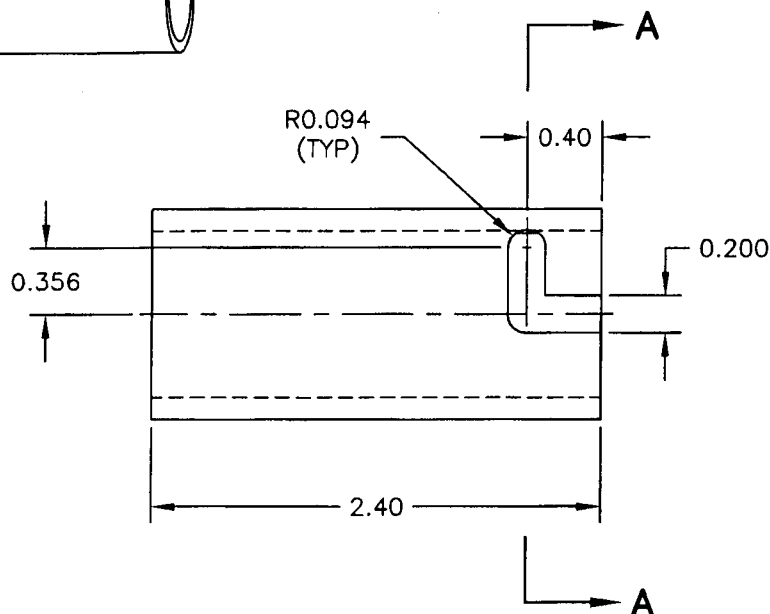
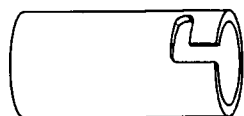
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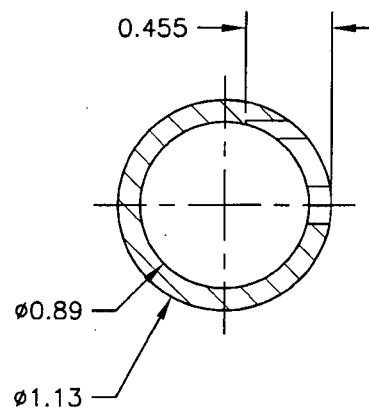
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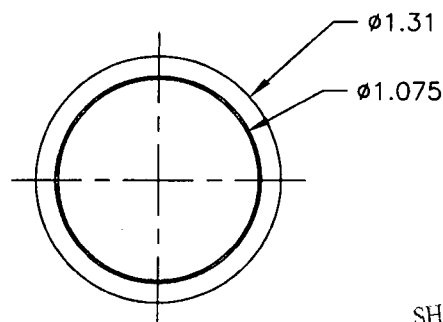
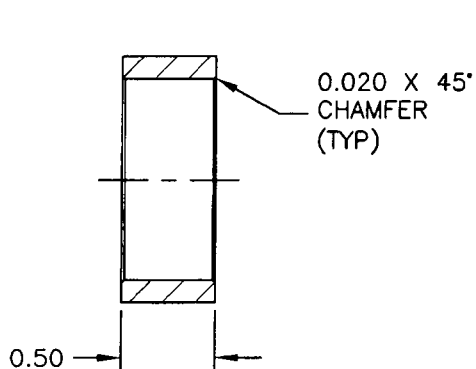


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**SECTION A-A**

**D3330-17 HANDLE SOCKET**



**D3330-19 HANDLE RIM**

**NOTES:**

- 1) MATERIAL: 1010-1025 ROUND BAR STEEL PER MILL-S-7097 (REF. DART SPEC. M1025TR)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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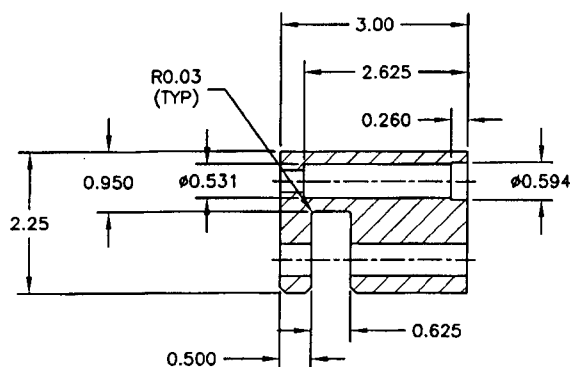
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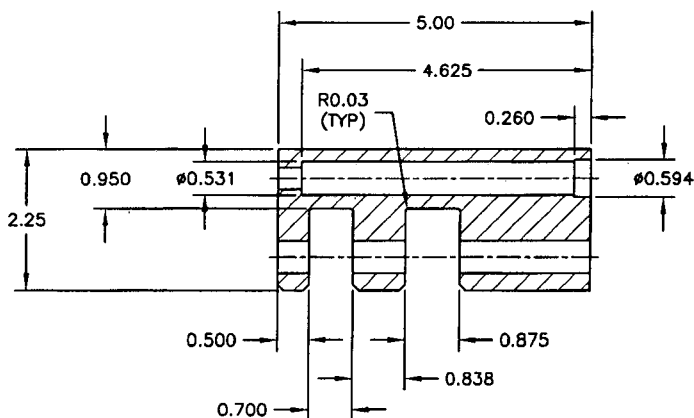
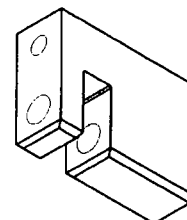
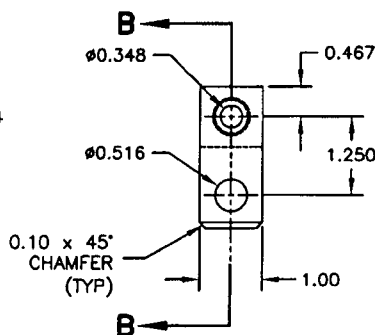
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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3330	REV. 0 SHEET 9 OF 9
DATE 07.12.06		TITLE FRAME WELDMENT	SCALE 1:3

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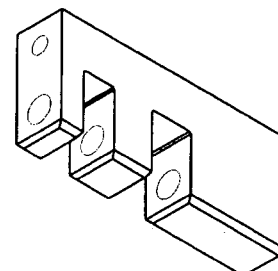
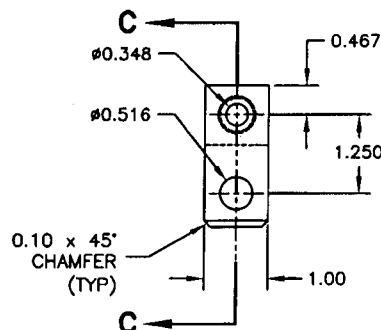
**SECTION B-B**

**D3330-13 SHORT PIN BRACKET**



**SECTION C-C**

**D3330-11 LONG PIN BRACKET**



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**NOTES:**

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A569/A570, 1.000 THICK STEEL (REF. DART SPEC. M1010-B1.000x02.250)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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